

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018487**Date Inspected:** 30-Nov-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC) Chanxing Island**Location:** Shanghai, China**CWI Name:** Mr. Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA), Vibin Kumar Selvanayaham, was present during the times noted above for observations relative to the work being performed.

Ultrasonic Testing (UT) – NWIT Document No: 007552

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Steel barrier at Bay 16. The weld designations reviewed are as follows:

1. W5-SB1-099-050
2. W5-SB1-062-050
3. W5-SB1D-012-019
4. W5-SB27-001-019
5. W5-SB1-071- 081
6. W5-SB1-059-050
7. W5-SB1-091-081
8. W5-SB1-068-050
9. W5-SB1-008-050

Ultrasonic Testing (UT) – NWIT Document No: 007553

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Bike Path at Bay 19. The weld designations reviewed are as follows:

1. BK004B7-001-079, 078
2. BK005A7-007, 009, 037
3. BK4ASD1-014-005, 006, 018, 021
4. BK4BSD1-001-005, 006, 018, 021

Ultrasonic Testing (UT) – NWIT Document No: 007556

This QA inspector performed UT of approximately 10% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an UT report for this date. The members are identified as OBG Steel barrier at Bay 16. The weld designations reviewed are as follows:

1. W5-SB1-040-019

Magnetic Particle Testing (MT) – NWIT Document No's: 007550

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. The members are identified as OBG Steel barrier at bay 16. The weld designations reviewed are as follows:

1. W5-SB1D-009-032, 034, 036, 051, 055, 044

Green Tag for OBG Component – Steel Barrier

This QA inspector performed Visual Inspection for Green Tagging which were previously tested and accepted by ZPMC Quality Control and ABF QA personnel. This QA signed green tag number is identified 15183. The OBG component are identified as given below

1. W5- SB19-001
2. W5- SB1-067
3. W5- SB22-001
4. W5- SB1-038
5. W5- SB1D-009
6. W5- SB1-066
7. W5- SB1-061
8. W5- SB1-058
9. W5- SB1-053
10. W5- SB28-005
11. W5- SB1-048

Bay 19

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) welding of weld joint is identified as BK004A3-013-002, 009 located on OBG bike path. ZPMC Welder is identified as 062732. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS –B-T-2232-Tc-P4-F.

FCAW welding of weld joint is identified as BK004A5-013-002, 008 located on OBG bike path. ZPMC Welder is identified as 062808. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS –B-T-2232-Tc-P4-F.

FCAW welding of weld joint is identified as BK004A3-013-002, 010 located on OBG bike path. ZPMC Welder is identified as 062732. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS –B-T-2233-Tc-P4-F.

FCAW welding of weld joint is identified as BK004A3-013-004, 007 located on OBG bike path. ZPMC Welder is identified as 062808. ZPMC Quality Control (QC) is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appeared to comply with the Applicable WPS –B-T-2233-Tc-P4-F.

This QA inspector observed ABF personnel performed Magnetic Particle Testing on OBG Bike Path BK004B-001.

Visual Inspection after Blast

OBG Segment 12CE

This QA Inspector performed a preliminary random visual inspection on OBG Segment 12CE, after the grit blast of the exterior components bottom plate, floor beams, side plates and corner assemblies of this segment panel point PP116 to P118. Areas of visual weld defects that will require welding were taped and will be repaired after the coating is applied. ZPMC QC personnel are aware of these areas and were present during the inspection.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact , who represents the Office of Structural Materials for your project.

Inspected By:	Kumar,Vibin	Quality Assurance Inspector
Reviewed By:	Patel,Hiranch	QA Reviewer
